

Date: Monday, 6/5/2006 7:47:10 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 27365		
Estimate Number	: 10367		
P.O. Number	: N/A	Part Number	: D31121
This Issue	: 6/5/2006 S.O. No. : N/A	Drawing Number	: D3112 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 24674	Material	: N/A
Written By	: <i>SA</i> (COMMENT Below)	Due Date	: 6/30/2006
Checked & Approved By	: <i>SA 06-06-05</i>	Qty:	6 Um: Each
Comment	: Est. A 02.05.22 New Issue NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0625X01500	6061-T6 Bar .625" x 1.5"
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Comment: Qty.: 0.2385 f(s)/Unit Total : 1.4307 f(s)  
 6061-T6 Bar .625 X 1.500"  
 Material: 6061-T6/T6511/T651 ( QQ-A-225/8 OR QQ-A-200/8)  
 Bar ref DART spec M6061T6B  
 Batch *M17037*

*ml 06/06/01*

6

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks: 0.625" x 1.500 bar x 2.625" long.

*ml 06/06/11*

6

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA233  
 Note: Engrave / scribe DART P/N on part as per dwg.  
 Deburr break all unmarked sharp edges .005 to 0.010

*ml 06/06/12*

6

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 06/06/12*

6

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SA 06/06/13*

x6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/21

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:47:10 AM  
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## Process Sheet

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Drawing Name: GUIDE

Job Number: 27365

Part Number: D31121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06.06117 (5)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

06.0606119 (5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

26/6/20 (5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 57408

26/6/20 (5)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21


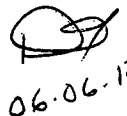

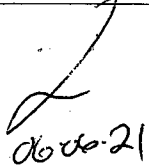
28 06/06/21 (5)

Job Completion



4 06.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.06.17	6	Lost one in sewer when abocline		Lost and Not Found	STB 06.06.17	 06.06.17.	 06.06.17	 06.06.21

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	27365
<b>Description:</b> Guide		<b>Part Number:</b>	D3112-1
<b>Inspection Dwg:</b> D3112	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.001	✓			
0.500	+/-0.010	0.504	✓			
R0.063	+/-0.010	R0.063	✓			
0.125	+/-0.010	0.129	✓			
0.500	+/-0.010	0.499	✓			
0.250	+/-0.010	0.250	✓			
0.155	+/-0.010	0.155	✓			
1.005	+/-0.010	1.004	✓			
0.412	+/-0.010	0.411	✓			
0.191	+/-0.010	0.191	✓			
2.000	+/-0.010	2.000	✓			
2.500	+/-0.010	2.499	✓			
Ø0.191	+0.005/-0.000	Ø0.192	✓			
R0.125	+/-0.010	R0.125	✓			

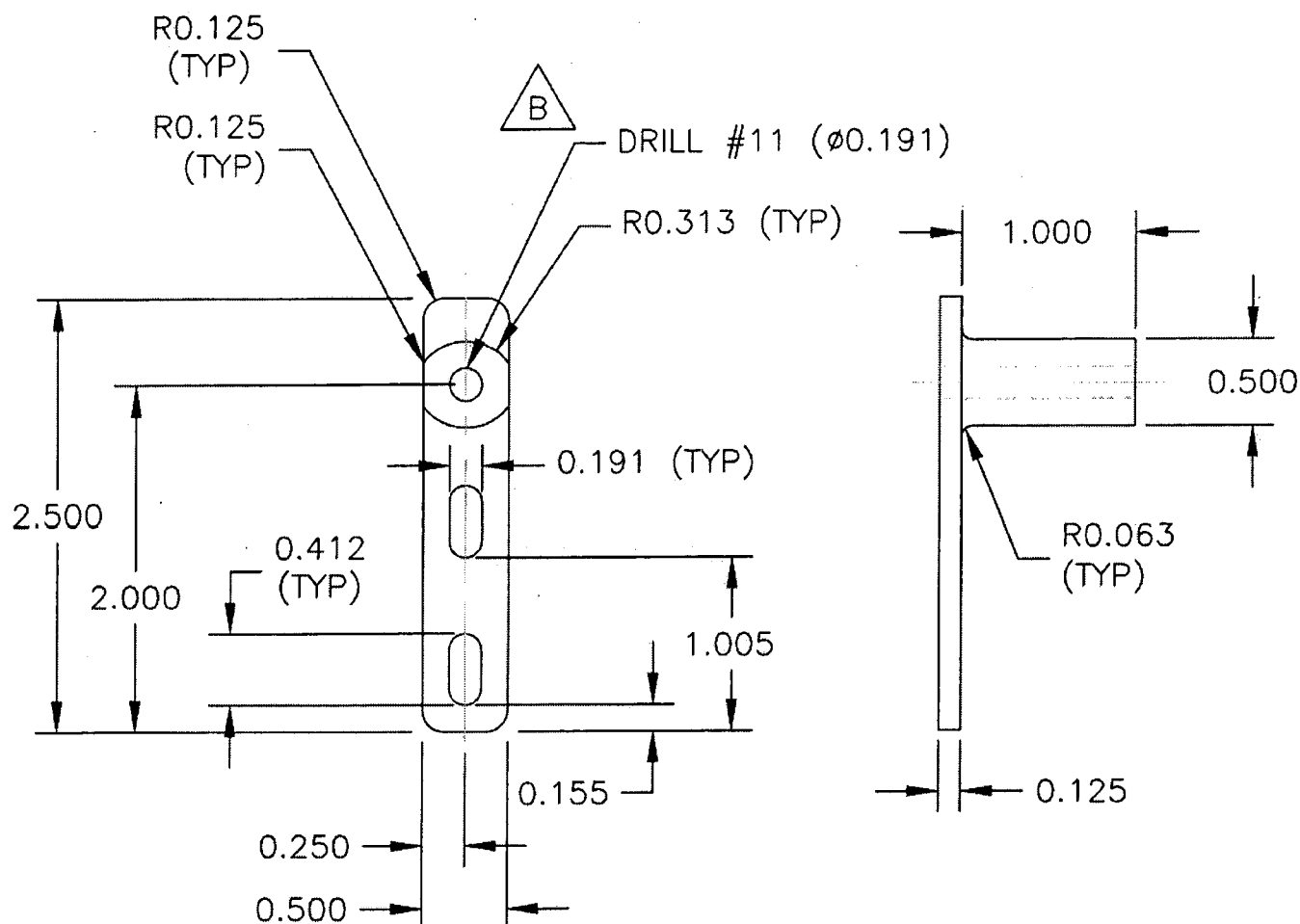
<b>Measured by:</b>	<i>ml</i>	<b>Audited by:</b>	<i>MS</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/06/12	<b>Date:</b>	06/06/12	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.07.07	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3112	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE GUIDE	SCALE 1:1
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; $\phi 0.191$ WAS $\phi 0.185$	

RELEASED  
04.11.23



### D3112-1 GUIDE

#### NOTES:

- 1) MATERIAL: 6061-T6/T6511/T651 (QQ-A-225/8 OR QQ-A-200/8)  
BAR (REF. DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-17
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27365

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